

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009178**Date Inspected:** 13-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Dong An, Li Hong Fei, Zhang Cui			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint NSD1-FASA4-1A/E-10 located on north tower, lift 4, skin A. Welders were identified as 057180, 040338. ZPMC QC was identified as Liu Dong An (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4132. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Yang Yi Heng.

FCAW welding of weld joint NSD1-FASA4-1A/E-15 located on north tower, lift 4, skin A. Welders were identified as 040533, 053869. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Yuan Hui Gang, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-4132. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Yang Yi Heng.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

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SMAW welding of weld joints WSD1-FESA4-4C/F-10, 15 located on west tower, lift 4, skin E. Welder was identified as 066480. ZPMC QC was identified as CWI Li Hong Fei (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Fu Wei Min, who was not a CWI. The welding variables recorded by QC2 and QC2's assistant appeared to comply with WPS-345+485-SMAW-2G(2F)-repair.

FCAW welding of weld joints ESTL3-4B/K-77, 78 located on east tower, lift 3, 89M to 92.5M diaphragms. Welders were identified as 070212, 060882. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2332-Tc-P5-F for weld 77 and WPS-B-T-2331-Tc-P5-F for weld 78.

FCAW welding of weld joints ESTL3-4G/K-97 located on east tower, lift 3. Welder was identified as 068206. ZPMC QC was identified as CWI Zhang Zhi Neng (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-4333-Tc-P5-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations on this date except as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
